

**Data**

Ring gear wobble	max. 0.4
Centering flange dia. for ring gear	268.31—268.39
Shrink-fit temperature	220 °C
Tempering color	yellow

**Commercially available accessories**

Temperature indicator chalk color No. 2815/220 (white) Thermochrom	e.g. AW Faber-Castell 8504 Stein bei Nürnberg
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**Note**

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The ring gear is hardened. In order not to damage the hardening be sure not to exceed 220 °C at any point when heating up the ring gear. To make certain it is essential to use a hot plate or an oven.

Flame heating is only permissible in exceptional cases. Even then, the flames are to touch only the inside of the ring gear.

Having replaced a ring gear, it is not necessary to balance the flywheel.

**Replacement**

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- 1 Spot-drill old ring gear and chisel off — or heat up quickly and then remove immediately.
- 2 Clean ring gear contact surface on flywheel.
- 3 Heat new ring gear evenly, using hot plate or oven. If possible, use temperature indicator chalk in accordance with maker's directions.

4 Immediately fit hot ring gear on flywheel.

**Caution:**

Tooth chamfering (arrow) must point toward starter.

The spares service only supplies ring gears with chamfered teeth.

These ring gears are also to be installed in vehicles with manual transmissions, replacing the types without tooth chamfering.

